

Work Order ID 110089

December-17-13 9:07:58 AM

110089

Page 1

Item ID: D2562-001

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Strut 19.68"

Start Date: 12/17/13 Start Qty: 6.00

6

Cust Item ID:

Required Date: 12/17/13 Req'd Qty: 6.00

6

Customer:

Reference:

Run Start

NR1

Approvals: Process Plan: MLJ

Date: 13-12-19

Tooling:

Date:

Stop

NR2

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D2562

Rev D

100

0.00

100

NC BRAKE

Brake NC

Memo

0.00

Brake NC

Punch to length as per Dwg D2562

86

FF
14-05-27

110

0.00

110

Small Fab

Small Fab

Memo

0.00

Small Fab

1- Bend end as per Dwg D2562 Angle "D"2-Debur

86

FF
14-05-27

120

0.00

120

QC5- Inspect part completeness to step on W/O

QC

Memo

0.00

Quality Control

DAS
27
9-89

14/5/27

86

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Page 2

Packaging

410

9-89

MAY 29 2014

Work Order ID 110089

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Page 3

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Accept

N900040100

Setup Start

NS1

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Customer:

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Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00

160

QC

Memo

0.00

Quality Control

ML5 14-06-02

14-05-30

Picklist Print

December-17-13 9:07:57 AM

Page 1

Work Order ID: 110089

Parent Item: D2562-001

Parent Item Name: Strut 19.68"

Start Date: 12/17/13

Required Date: 12/17/13

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP F02.04.15Added dwg Rev.B1 NG

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M304TR0.500W.035 304 RD Tube .500 x .035W		Purchased	No			100	f	263.4058	1.7067	10.779158			
--	--	-----------	----	--	--	-----	---	----------	--------	-----------	--	--	--

FF 14-05-27

Location

Loc Qty

Loc Code

MAT017 129100
118702
123303
125513
m126922

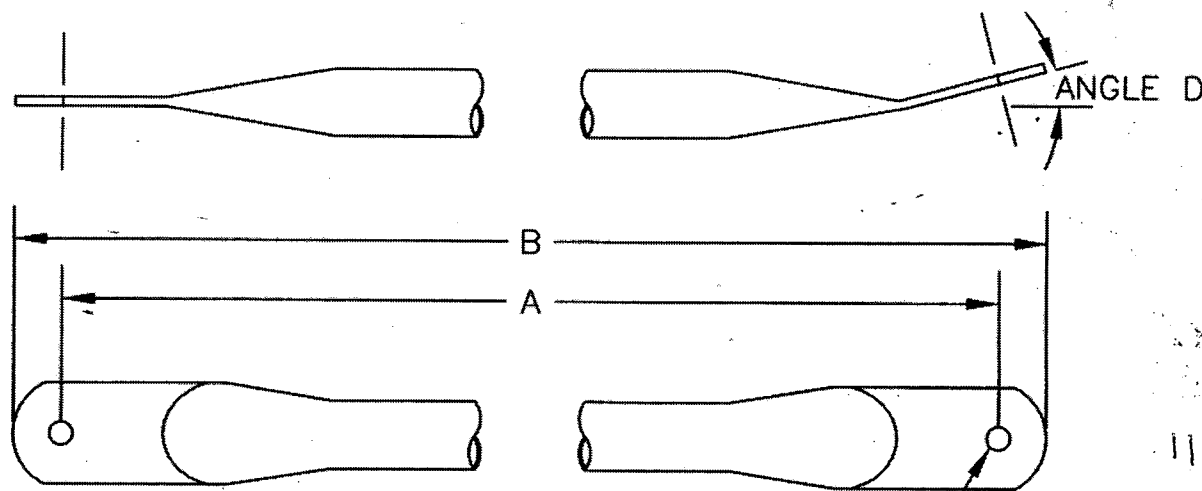
263.4058225
0.00003
138.9645
72.9014525
51.53984

10.779

DART

110089 MLS
1312-19

DESIGN	CP	DRAWN BY	RF	DART AEROSPACE LTD
CHECKED		APPROVED		HAWKESBURY, ONTARIO, CANADA
DATE	05.05.18	TITLE	D2562	REV. D
		STRUT		SHEET 1 OF 1
A	96.05.01	NEW ISSUE		SCALE
B	98.10.15	*UPDATED MATERIAL NOTE (TSR A603)		1:2
C	02.06.05	ADD -005; ADD FINISH		
D	05.05.18	ADD -007/-011/-013; UPDATE -005		



"C" DIA TO BE OPENED MANUALLY
PUNCH ENDS PER SPEC CONTROL DRAWING D2727

20.73

PART #	DIM A	DIM B	DIA C	ANG D
D2562-001	19.68	20.48	-	10
D2562-003	20.37	21.17	-	18
D2562-005	29.00	29.80	-	30
D2562-007	19.22	20.02	-	0
D2562-011	25.79	26.59	-	16
D2562-013	26.63	27.43	-	24

GENERAL NOTES

- 1) MATERIAL: AISI 304/316/318 SS 0.500 OD X 0.035 WALL (REF DART SPEC. M304TR0.500W.035)
ENSURE SEAMLESS TUBE IS USED
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

RELEASED

05.05.27

DART AEROSPACE LTD

Work Order:

110084

Description: STRUD 19.68"

Rev:

5

Part Number:

D 2562-001

INSPECTION SHEET

[illegible]

Measured by:

7

Date _____

14-05-27

Checked By:

**DAS
30
9-89**

Date

14605 | 28

QC inspector: DAS

27
9-89

Date _____

14/5/27

Engineering Approval (if not)

Date _____